

Work Order ID 158872

Monday, April 03, 2017 11:40:33 AM

158872

Page 1

Item ID: D3825-043 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Rib Assembly (Basket End, Lid)
Start Date: 4/3/2017 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 4/6/2017 Req'd Qty: 8.00 *8* Customer:
Reference: SCHEDULED

Approvals: Process Plan: APR 03 2017 Date: Tooling: Date: Run Start *NR1*
QC: DAS 21 9-09 Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3825	C								

100

100

Large Fab

Large Fab

Large Fab

Memo

1- cut D3825-3 rib as per dwg D3825

2- drill hole (3/16") in D3825-3 using DT9822 jig and open to finish size as per dwg D3825

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D2327-1 spacer & D4021-9 bushing as per dwg D3825

A/R S.S. Rod Batch: 136695

7- grind bushing weld flush where indicated on dwg D3825

8- deburr if necessary

0.00

1.92

8x 17-04-06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 158872

158872

Page 3

Monday, April 03, 2017 11:40:33 AM

Item ID: D3825-043 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Rib Assembly (Basket End, Lid)
Start Date: 4/3/2017 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 4/6/2017 Req'd Qty: 8.00 *8* Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21 - Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.80							
Quality Control									

DAS
21
9-89

APR 10 2017

Picklist Print

Monday, April 03, 2017 11:40:37 AM

Page 1

Work Order ID: 158872

158872

Parent Item: D3825-043

D3825-043

Parent Item Name: Rib Assembly (Basket End, Lid)

Start Date: 4/3/2017

Required Date: 4/6/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 12.07.24 AS PER REV.B DD VERF:EC
REV:B 12.08.08 AS PER DWG REV.C DD VERF:EC IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-1 ✓ *D2327-1* Spacer Bushing		Manufactured	No			100	Each	24.0000	1	8			
---	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

**** BISS959 17-04-06 C/**
8v

Location	Loc Qty	Loc Code
WA004	24	
155959	24	

D4021-9 ✓ *D4021-9* Bushing		Manufactured	No			100	Each	100.0000	2	16			
--	--	--------------	----	--	--	-----	------	----------	---	----	--	--	--

**** BISS371 17-04-06 C/**
16r

Location	Loc Qty	Loc Code
WA004	100	
145800	2	
155371	98	

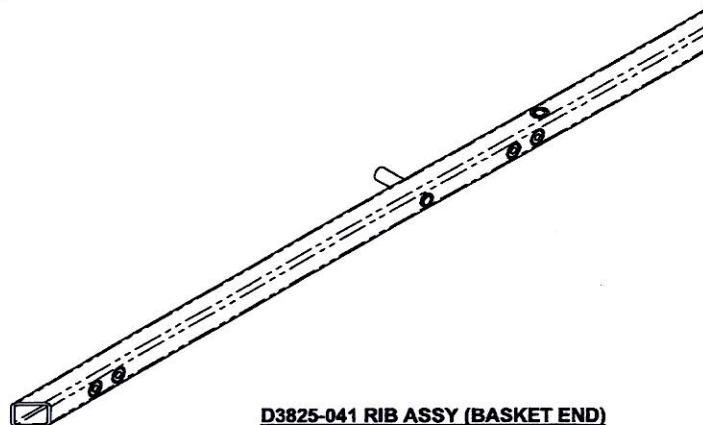
M304TS0.750W.065 ✓ *M304TS0 750W 065* 304 SQ Tube .75x.75x.065W		Purchased	No			100	f	435.0000	2.125	17.89474			
--	--	-----------	----	--	--	-----	---	----------	-------	----------	--	--	--

**** 20 17-04-06 C/**
B137065

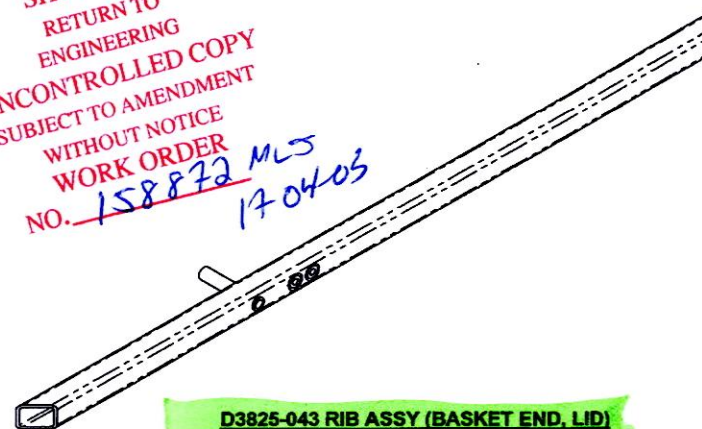
Location	Loc Qty	Loc Code
WA004	435	
m137065	435	

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3825-041	RIB ASSEMBLY (BASKET END)
		X	D3825-043	RIB ASSEMBLY (BASKET END, LID)
1		1	D2327-1	SPACER BUSHING
2	1		D2327-3	SPACER BUSHING
3	1		D3759-1	BUSHING
4	1		D3825-1	RIB
5		1	D3825-3	RIB
6	4	2	D4021-9	BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158872 *MLS*
170405



D3825-041 RIB ASSY (BASKET END)



D3825-043 RIB ASSY (BASKET END, LID)

RELEASED
2012-08-03
WJP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3825-041 = 1.27 lbs; D3825-043 = 1.23 lbs
- 8) WELDING: PER DART QSI 004

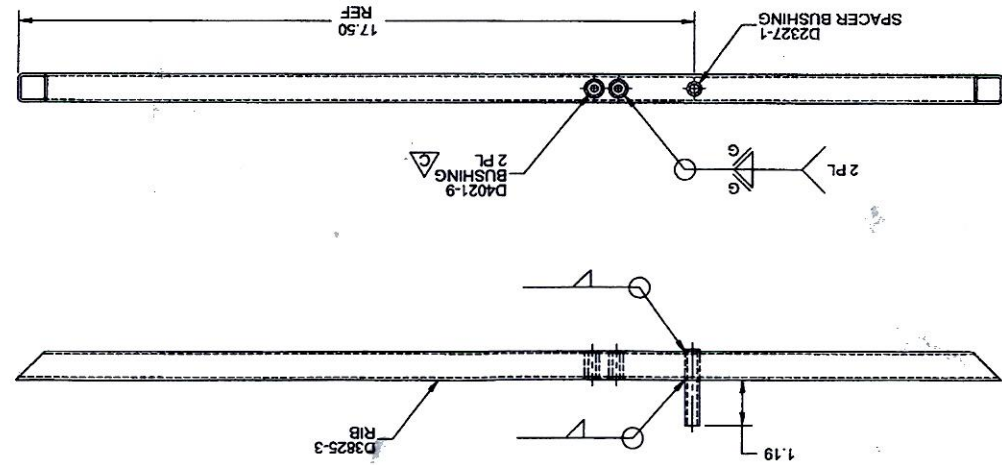
C	QTY(4) D4021-9 ON -041 AND QTY(2) D4021-9 ON -043 WERE D3759-1. CORRECTED DIM (Z4 B3-4): WAS 14.875. REASON FOR CHG: AN3 SIZE BOLTS REQ'D IN THOSE LOCATIONS.	MB	12.07.18
B	QTY(5) FOR D3759-1 WAS QTY(1): AFFECTS D3825-041-1 (ZNS D3-1, C4-2, C3-2, D4-4, C6-4, C4-4, C3-4). ADDED D3825-043-3. REASON: PAR10-50.	MB	12.05.11
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AL</i>		
DRAWN	<i>AP</i>		
CHECKED	<i>AP</i>		
MFG. APPR.	<i>AP</i>		
APPROVED	<i>WJP</i>		
DE APPR.	<i>WJP</i>		
DATE	12.07.18		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		DRAWING NO. D3825	REV. C
TITLE RIB ASSY (BASKET END)		SCALE NTS	SHEET 1 OF 4
COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE MANNER SPECIFIED HEREIN. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION FROM DART AEROSPACE LTD.			

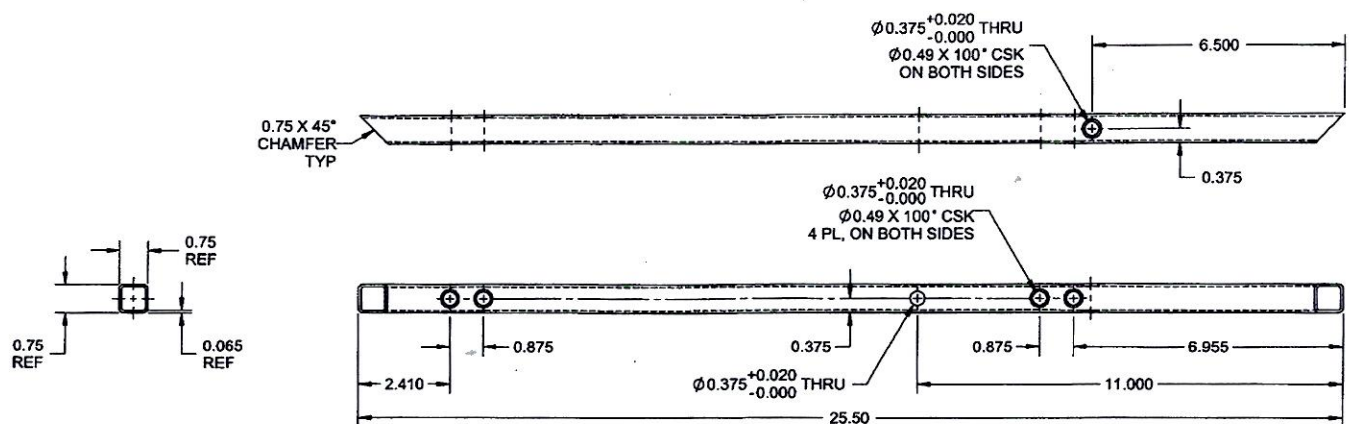
RELEASED
2012-08-03

DESIGN	DATE	12.07.18
DRAWN	DE APPR.	
CHECKED	APPROVED	
DRAWING NO.	MFG. APPR.	
REV. C	D3825	
HAWKESBURY, ONTARIO, CANADA		
DART AEROSPACE LTD		
SHEET 3 OF 4		
SCALE		
NTS		
COPYRIGHT © 2008 BY DART AEROSPACE LTD		
THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES SPECIFIED ONLY AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.		

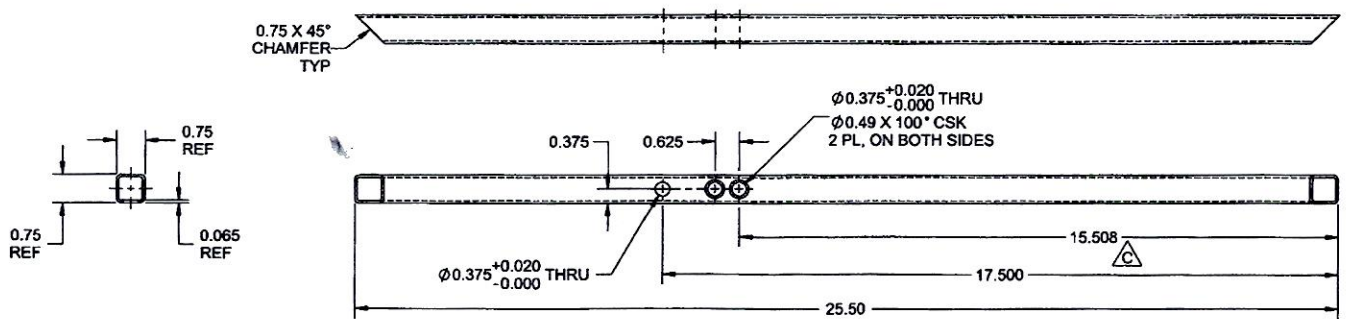
RELEASE
2012-08-03

D3825-043 RIB ASSY (BASKET END, LID)





D3825-1 RIB



D3825-3 RIB

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.16 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3825	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
DATE	12.07.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED
2012-08-03